

Work Order ID 80634

80634

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February-24-12 3:21:33 PM

Item ID: D3043-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment RH, A119
 Start Date: 24/02/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3043	Rev A								

100 Large Fab 0.00
 100'
 Large Fab Memo 0.00
 Large Fab 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G
 2-Deburr and bevel ends for welding

12.02.29 2 Ø

110 QC6- Inspect dimensions to drawing 0.00
 110
 QC Memo 0.00
 Quality Control

12.02.29

2x Ø

120 Large Fab 0.00
 120
 Large Fab Memo 0.00
 Large Fab 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808
 AR AL ROD Batch: 119785 + 120/69
 2-Grind Fwd End Cap weld flush

12.03.07 2 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 24/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

2 0 BE12/03/08

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

S-103/08

x2
PK

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

2X0/M-12/03/09

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Large Fab	0.00							
160									
Large Fab	Memo	0.00							
Large Fab	1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: <u>119785</u> 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

12.03.12

Ac 12.03.12

8/2/12

8/2/12

Y2
RH

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Touch up alodine	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
210									
Powdercoat	Memo	0.00							
Powder Coating	START Time: 8/30 OVEN TEMPERATURE: 320°F FINISH TIME: 9/00								
220	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing									

2X ✓ m/l 12/03/14

2 & (SP) 12/03/15 15

2X ✓ m/l 12/03/16
 (2/2/3/16) (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 24/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC3- Inspect Part Finish

0.00


230

QC

Memo

0.00

Quality Control

612/3/12 

240

Identify as per dwg & Stock Location: _____

0.00

240


Packaging

Memo

RPR 80633

0.00

Packaging

614/3/12 

250

QC21- Final Inspection - Work Order Release

0.00

250


QC

Memo

0.00

Quality Control

MC5 12/03/20

MC5 12/03/20


W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 80634

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Parent Item: D3043-042

D3043-042

Parent Item Name: Step Weldment RH, A119

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

111.7300

1

2

**

12.02.29

D2622-120C

Step Extrusion

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA013

95.36

75781

6.4

77612

88.96

2

D2734

Manufactured No

120

Each

75.0000

1

2

**

12.02.29

D2734

Step End Plate

Location

Loc Qty

Loc Code

WA

75

76985

75

2

D3040-1

Manufactured No

120

Each

2.0000

2

4

**

12.02.29

D3040-1

Mounting Lug

Location

Loc Qty

Loc Code

WA018

380808

2

48239

2

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3043-042

D3043-042

Parent Item Name: Step Weldment RH, A119

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3040-3

Manufactured No

120

Each

25.0000

2

4

D3040-3

Mounting Lug

**

12.02.29

Location

Loc Qty

Loc Code

WA018

25

76998

25

D2734

Manufactured No

160

Each

75.0000

1

2

D2734

Step End Plate

**

12.03.12

Location

Loc Qty

Loc Code

WA

75

76985

75

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *[Signature]*

COPY
80634 M.C.J
12/02/27

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

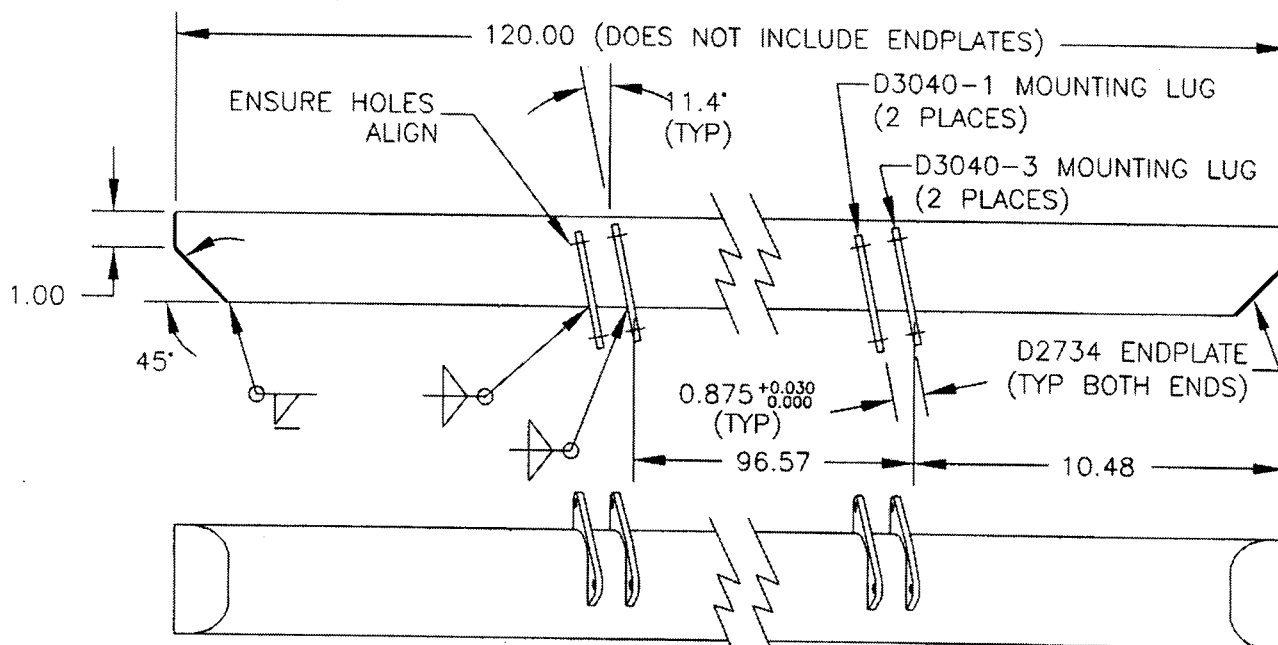
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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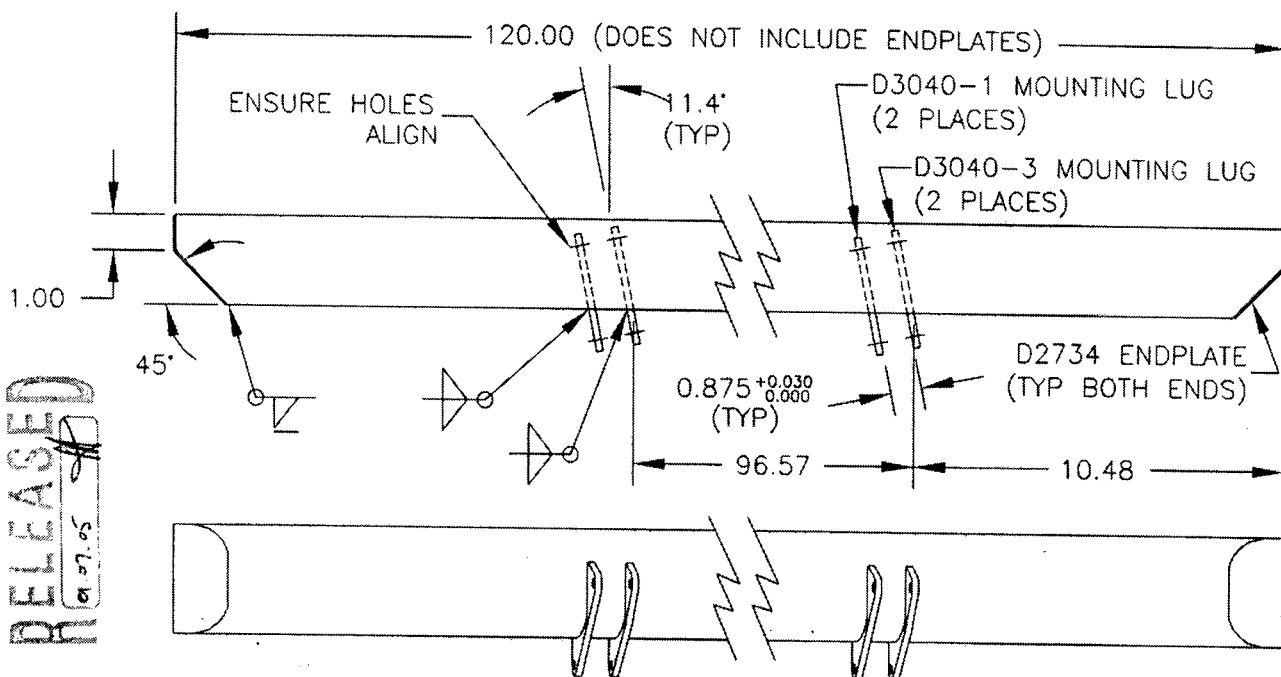
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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01-27-05

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